

Work Order ID 69114

Monday, May 02, 2011 11:13:01 AM

Page 1

Item ID: D3827-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib Assembly (Inboard)

Start Date: 5/2/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 5/5/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-2

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3827

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3827-1 rib as per dwg D3827

2- drill holes using DT9435 jig and open to finish size as per dwg D3827

3- c'sink as per dwg

4- remove identification markings

5- deburr

6- weld bushing in rib as per dwg D3827

A/R S.S. Rod Batch: 115528

7- grind weld flush

8- deburr if necessary

SAD 11-05-08

PC 11-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Work Order ID 69114




Page 2

Monday, May 02, 2011 11:13:01 AM

Item ID: D3827-041 Accept  Setup Start 
Revision ID:
Item Name: Rib Assembly (Inboard) Stop 
Start Date: 5/2/2011 Start Qty: 6.00  Cust Item ID:
Required Date: 5/5/2011 Req'd Qty: 6.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		S 11/15/16					
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		S 11/15/16		(+6)			
150  Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00		SAD 11-05-16		(6)			

W/O:		WORK ORDER CHANGES					
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Work Order ID 69114

Monday, May 02, 2011 11:13:01 AM



Page 3

Item ID: D3827-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Inboard)

Start Date: 5/2/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/5/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00




QC

Memo

0.00

Quality Control

11/5/18 
1105-18
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, May 02, 2011 11:13:06 AM

Page 1

Work Order ID: 69114

Parent Item: D3827-041

Parent Item Name: Rib Assembly (Inboard)



Start Date: 5/2/2011

Required Date: 5/5/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1 Bushing		Manufactured	No			100	Each	256.0000	3	18			
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Location Loc Qty Loc Code

WA005	256	
66489	56	
66870	200	

M304TS0.750W.065 304 SQ Tube .75x.75x.065W		Purchased	No			100	f	573.9018	8	50.52632			
---	--	-----------	----	--	--	-----	---	----------	---	----------	--	--	--

Location Loc Qty Loc Code

WA007	573.9017906	
116267	179.684072	
116763	394.217719	

Pl 11.05.16

SAO 11-05-08

50.5264

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

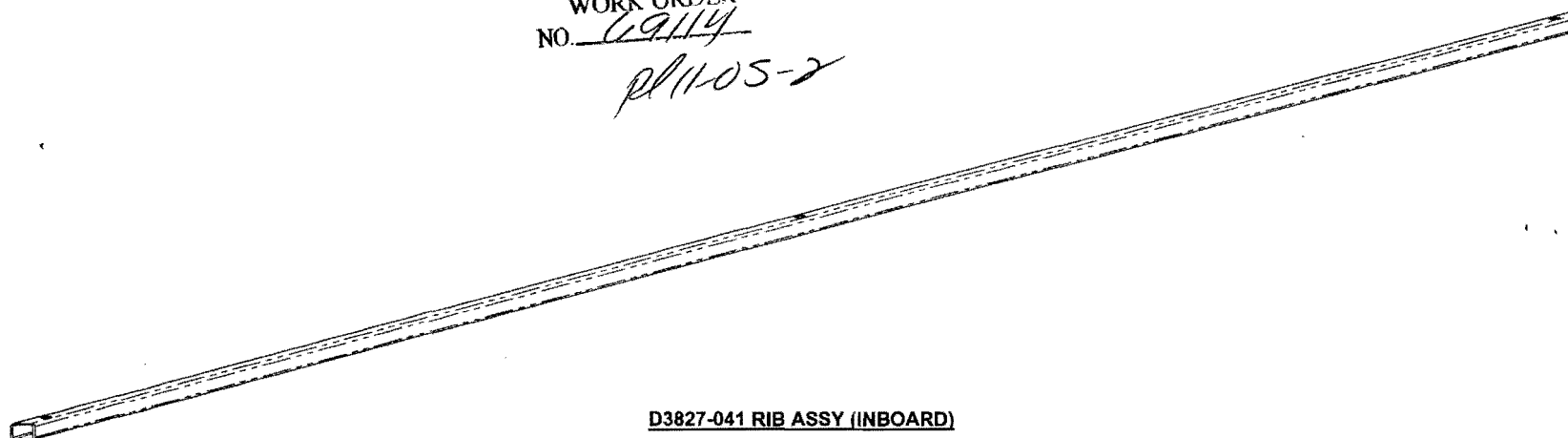
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69114

PL11-05-2



D3827-041 RIB ASSY (INBOARD)

RELEASED
08/11/23 MB

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 4.59 lbs

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB

A	NEW ISSUE	MB	08.09.23	
REV.		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3827 TITLE RIB ASSY (INBOARD)		
DRAWN				
CHECKED	ASS			REV. A
MFG. APPR.				SHEET 1 OF 3
APPROVED	AD			SCALE
DE APPR.				NTS
DATE	08.09.23		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

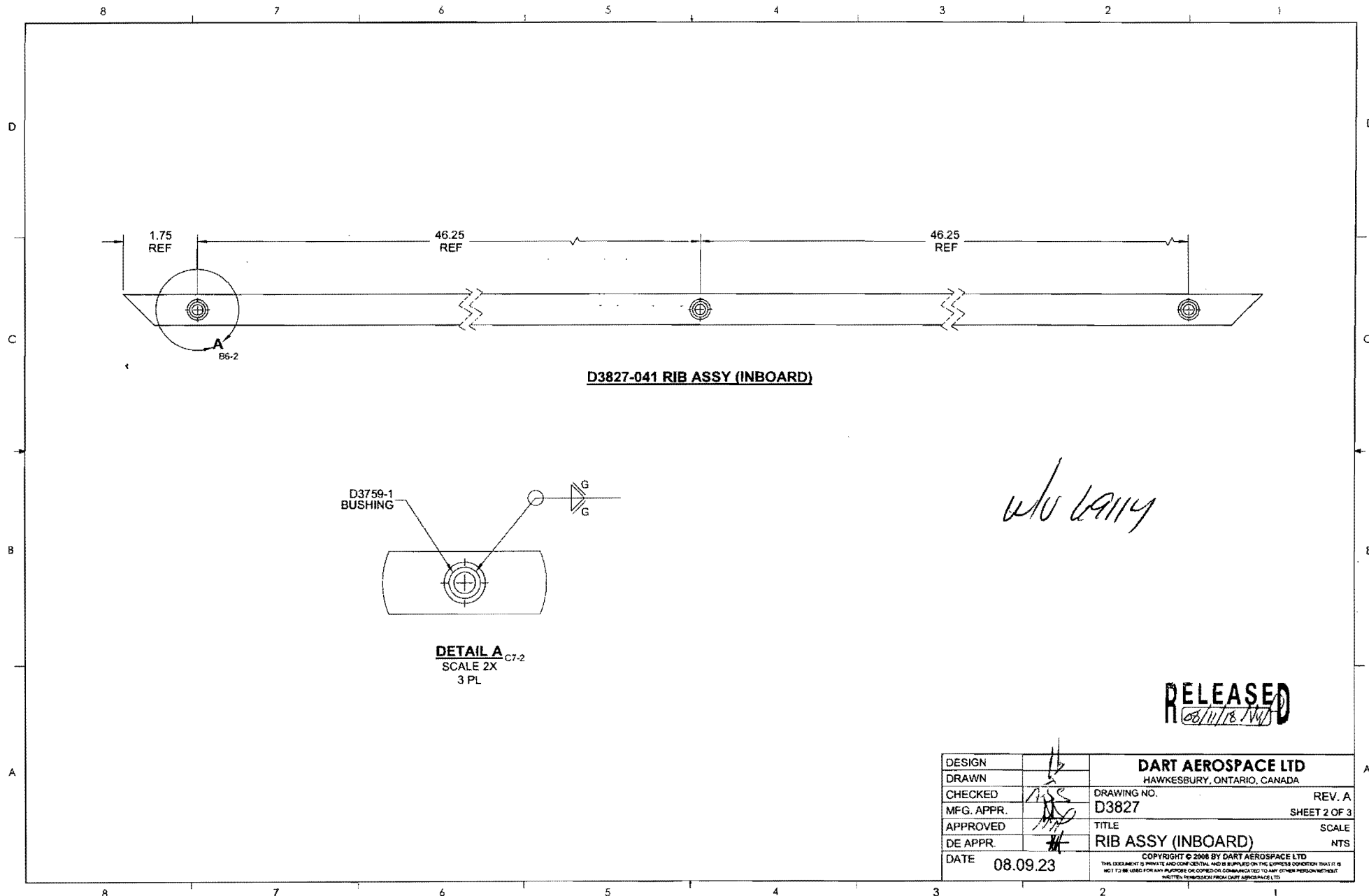
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NOTE: Date & initial all entries

$\varnothing 0.375^{+0.020}_{-0.000}$ THRU
 $\varnothing 0.49 \times 100'$ CSINK
 ON BOTH SIDES
 TYP

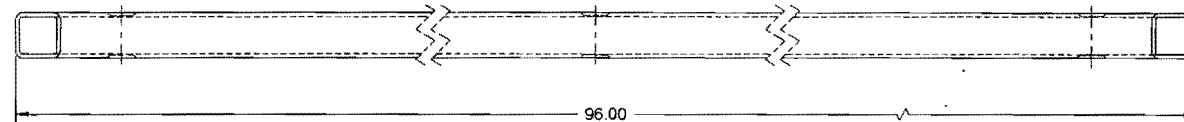
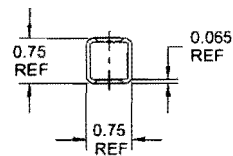
0.375

0.75 X 45° CHAMFER
 2 PL

46.250

46.250

1.750



D3827-1 RIB

W/0 GA114

RELEASED
08/11/14

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.55 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3827	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY (INBOARD)	NTS
DATE	08.09.23	<small> COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD </small>	

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